

Ship Nov. 25

Work Order ID 153546

153546

Page 1

Monday, November 21, 2016 10:20:12 AM

Item ID: D4888-041L02

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Dome Light Air Vent Assembly, Black

Start Date: 11/21/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 11/23/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

16-11-20

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4888

A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

DAS
07
9-89

16/11/21

110

0.00

110

Small Fab

Memo

0.15

Small Fab

Assemble as per Dwg D4888-041

DAS
07
9-89

16/11/21

1) Install air vents

2) Install lights

3) Install rheostats

4) Install wiring harness

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition			Completed By																		
24-1 TU 22-P							Lead hand / Supervisor Approval Verification																		
							QC / QA Coordinator Approval																		
Root Cause		FAULT CATEGORY																							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	OTHER : ☐																			

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153546

Page 2

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N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Dome Light Air Vent Assembly, Black

Start Date: 11/21/2016 Start Qty: 1.00

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Required Date: 11/23/2016 Req'd Qty: 1.00

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC6- Inspect dimensions to drawing	0.00				1			DAS 38 NOV 22 2016
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: <u>MF</u>	0.00				1			DAS 6 9-89
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							DAS 21 9-89
140									
QC	Memo	0.02							
Quality Control									

DAS
21
9-89

NOV 22 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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OTHER : _____																																																															

Picklist Print

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Page 1

Work Order ID: 153546

153546

Parent Item: D4888-041L02

D4888-041L02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 11/21/2016

Required Date: 11/23/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev A New Issue 13/09/13 DL

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4886-1 ✓ *D4886-1* Air Vent		Manufactured	No			100	Each	5.0000	2	2			DAS 07 9-89 16/11/21
					<u>Location</u>			<u>Loc Qty</u>					
					MF005			5					
					147622			5		2			DAS 07 9-89
D4888-1L02 ✓ *D4888-1L02* Dome Light Housing, Black		Manufactured	No			100	Each	2.0000	1	1			DAS 07 9-89 16/11/21
					<u>Location</u>			<u>Loc Qty</u>					
					MF006			2					
					151555			2		1			DAS 07 9-89
D4897-041 ✓ *D4897-041* Dome Light Wiring		Manufactured	No			100	Each	6.0000	1	1			DAS 07 9-89 16/11/21
					<u>Location</u>			<u>Loc Qty</u>					
					MF007			6					
					142110			2		1			
					147796			4					
D4898-1 ✓ *D4898-1* Screw, Stainless Steel		Manufactured	No			100	Each	6.0000	12	12			DAS 07 9-89 16/11/21
					<u>Location</u>			<u>Loc Qty</u>					
					MF006			6					
					141124			x 6		x 6			
					153289			-6?		x 6			

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Picklist Print

Page 2

Monday, November 21, 2016 10:20:17 AM

Work Order ID: 153546

153546

Parent Item: D4888-041L02

D4888-041L 02

Parent Item Name: Dome Light Air Vent Assembly, Black

Start Date: 11/21/2016

Required Date: 11/23/2016

Start Qty: 1.00

Required Qty: 1.00

✓ D4906-1 Manufactured No
D4906-1
Knob

100 Each 9.0000 1 1

DAS
07
9-89

Location Loc Qty Loc Code

MF004

9

151529

9

✓ MS21042L06 Purchased No
MS21042L 06
Nut

100 Each 76.0000 12 12

DAS
07
9-89

Location Loc Qty Loc Code

ST303

76

m135766

76

✓ NAS1149F0663P Purchased No
NAS1149F0663P
WASHER

100 Each 86.0000 3 3

DAS
07
9-89

Location Loc Qty Loc Code

ST262

86

M134365

86

✓ NAS1149FN632P Purchased No
NAS1149FN632P
Washer

100 Each 81.0000 12 12

DAS
07
9-89

Location Loc Qty Loc Code

ST264

81

m129163

81

Monday, November 21, 2016 10:20:17 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

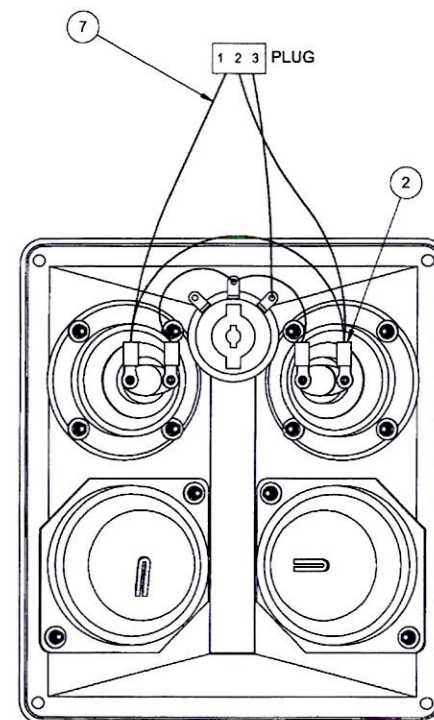
QA Closed: _____ Date: _____

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ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4888-041	DOMELIGHT AIR VENT ASSEMBLY
2	4	D4290-21 (REF)	RING TERMINAL (PART OF D4897-041)
3	1	D4864-1 (REF)	RHEOSTAT (PART OF D4897-041)
4	2	D4872-1 (REF)	LIGHT FIXTURE (PART OF D4897-041)
5	2	D4886-1	AIR VENT
6	1	D4888-1	DOMELIGHT HOUSING
7	1	D4897-041	DOMELIGHT WIRING HARNESS
8	12	D4898-1	SCREW
9	1	D4906-1	KNOB
10	12	MS21042L06	NUT
11	3	NAS1149F0663P	WASHER
12	12	NAS1149FN632P	WASHER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153546
16-10-70



RELEASED
2013-09-16

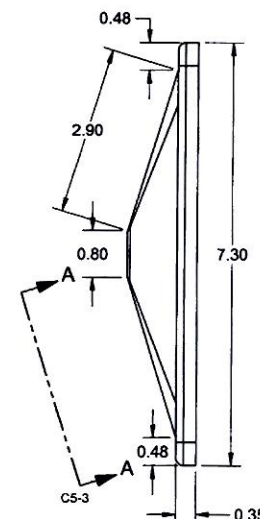
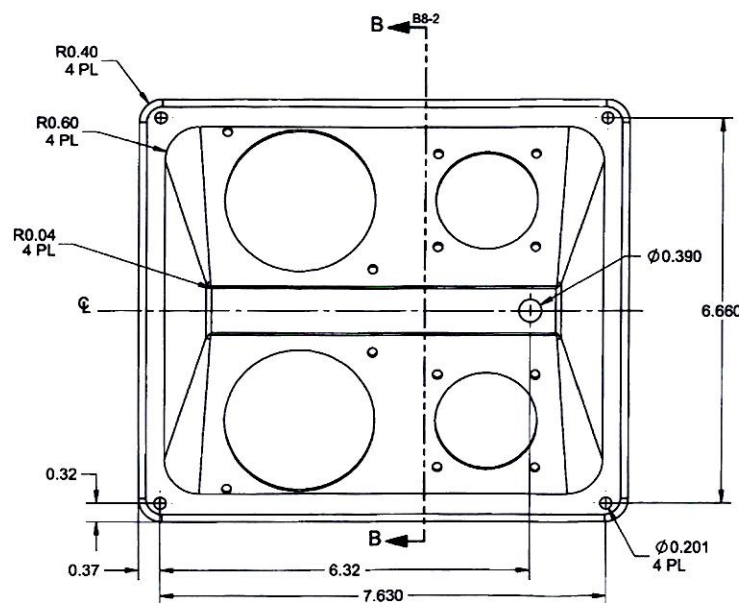
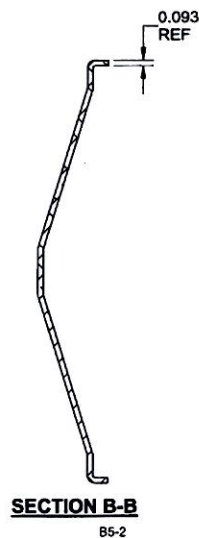
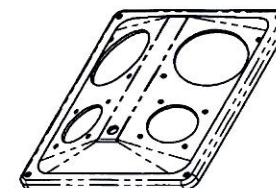
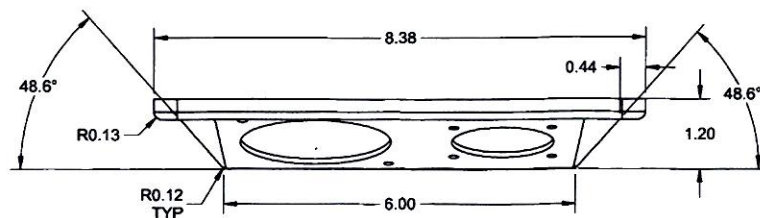
D4888-041 DOME LIGHT AIR VENT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.43 lbs
- 8) REPLACES GENEVA P/N GA129-12 P112-L
- 9) OPTIONAL: USE ADDITIONAL WASHERS TO SHIM AS REQUIRED
- 10) NUT INCLUDED WITH RHEOSTAT

A	NEW ISSUE	13.07.11
REV.	DESCRIPTION	BY DATE
DESIGN	DART AEROSPACE USA, INC.	
DRAWN	KENT, WA	
CHECKED	DRAWING NO.	REV. A
MFG. APPR.	D4888	SHEET 1 OF 3
APPROVED	TITLE	SCALE
DE APPR.	DOMELIGHT AIR VENT ASSY	NTS
DATE	13.07.11	

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RELEASED
2013-09-16

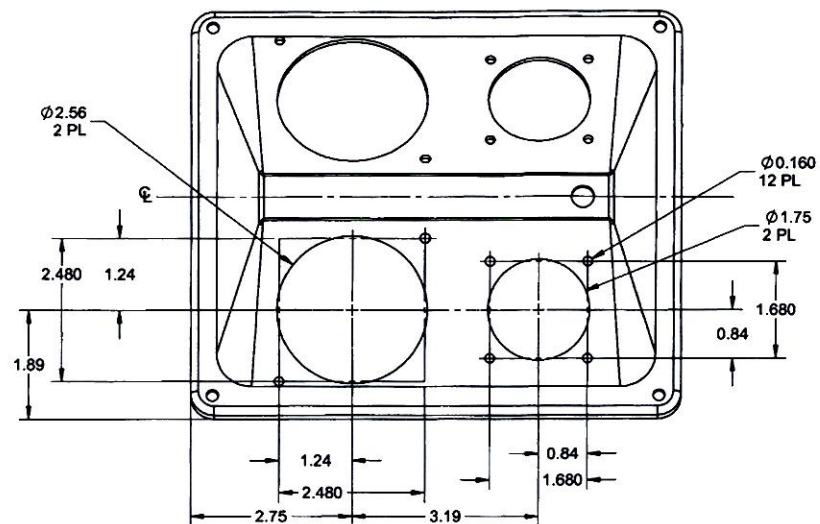
NOTES:

- 1) MATERIAL: SEE TABLE
- 2) TOOLING: THERMOFORM PER MOLD DT9932 PER QSI 022 TRIM PER DT9932
- 3) FINISH: N/A
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: N/A
- 8) WEIGHT: 0.22 lbs
- 9) REPLACES GENEVA P/N GA129-7
- 10) PART SHAPE AND GEOMETRY IS CONTROLLED BY TOOLING
- 11) MINIMUM THICKNESS AFTER FORMING IS 0.060" FOR FLANGES AND 0.070" ELSEWHERE

D4888-1 DOME LIGHT HOUSING

PART NUMBER	DESCRIPTION
D4888-1LBL	F6006 SUEDE/POLISHED 701 BLACK LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-02)
D4888-1LLG	F6006 SUEDE/POLISHED GY5B133 LIGHT GREY LEXAN SHEET 0.093 THICK (REF DART SPEC MLEXS.093-F6006-07)

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4888	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		DOME LIGHT AIR VENT ASSY	NTS
DATE	13.07.11	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC.	
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VIEW A-A
B2-2

RELEASED
2013-09-16
M

DESIGN	OS	DART AEROSPACE USA, INC.	
DRAWN	OS	KENT, WA	
CHECKED	OS	DRAWING NO.	REV. A
MFG. APPR.	OS	D4888	SHEET 3 OF 3
APPROVED	OS	TITLE	SCALE
DE APPR.	OS	DOMELIGHT AIR VENT ASSY	NTS
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